



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C3-8-2-1

Job Sheet 180821



Part No: C3-8-2-1

Job Qty: 2 ea

Part Name: Solenoid



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/17/18

Job Tracking No:

Due Date: 7/18/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG C3-8-2 Rev 3 IPP Rev A 18.04.09 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	7/18/18	7/18/18	0.00	0.00	Start Up Machining-4		
100	Mill Conv	2 pcs	7/18/18	7/18/18	0.50	0.40	Mill Conv 2		
110	QC	2 pcs	7/18/18	7/18/18	0.00	0.00	QC2 Machining-5		
120	QC	2 pcs	7/18/18	7/18/18	0.00	0.00	QC8 Machining-5		
130	Packaging	2 pcs	7/18/18	7/18/18	0.00	0.00	Packaging3-2		
140	QC21-SA	2 Ea	7/18/18	7/18/18	0.00	0.00	QC21		

Part Op 100 - 1-USE C3-8-2-F1FIXTURE FOR DRILLING THE PIN HOLE. 2-REMOVE COIL SPRING BEFORE DRILLING
Descriptions: HOLE. 3-TURN SHAFT AS SHOWN IN FIXTURE BEFORE DRILLING (CLOCKWISE). 4-Engrave S/N and/or P/N
number using Marktronic engraver as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
152951-001	Solenoid	2 Ea (1 ea)	90-Start up Operation	5082463

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	152951-001	2	50	0

Part Specifications

Specifications could not be found.



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Plex 7/17/18 8:57 AM dart.white.jesse

Container No: S092941



Part: C3-8-2-1

Job No: 180821

Serial No/Batch: S092941

Revision:

Inspector:

Exp Date:

Instructions:

Date: 07/18/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

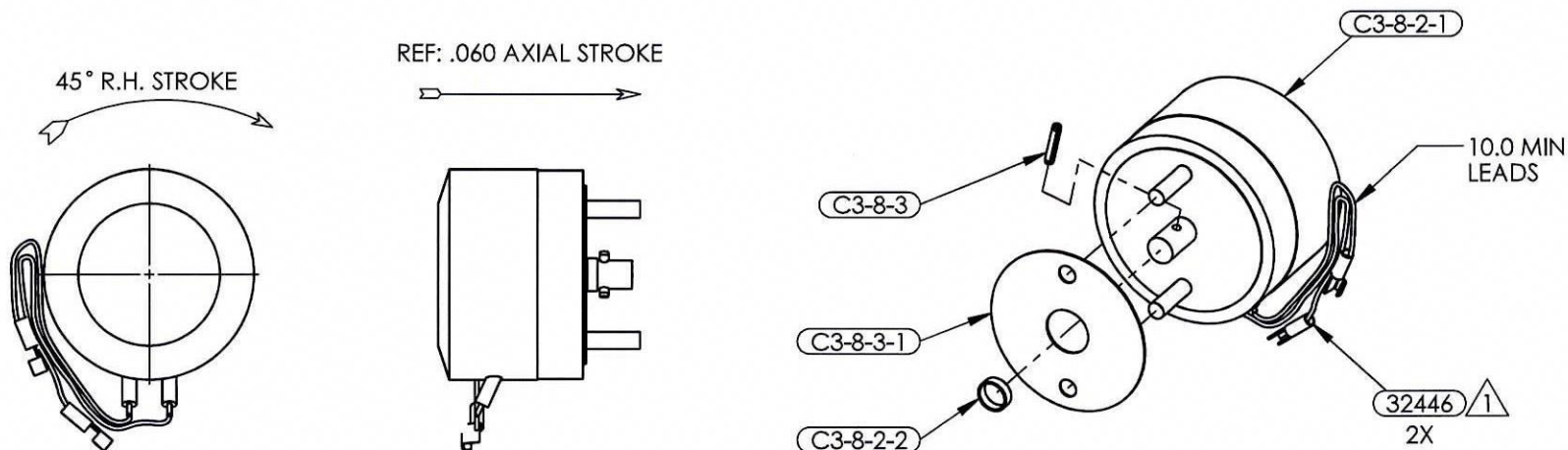
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		ADDED SPACER C3-8-31.	10/10/2012	RJC	DW
1A	14-0111	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED ENGRAVE NOTE. ADDED NOTE ¹ .	8/7/2014	DJN	RW
2	14-0195	C3-8-2-1 CH'D DIM WAS LIMITS Ø.0933-.0937 IS LIMITS Ø.094-.097. ADDED "(CLOCKWISE)" TO NOTE ³ . CH'D NOTE 4 WAS PLACE BUSHING AND PIN IN PLACE AS SHOWN AFTER DRILLING IS INSTALL SPACER AND PIN IN PLACE AS SHOWN ON SHEET 1 AFTER DRILLING. ADDED ENGRAVE BATCH NUMBER NOTE. C3-8-3-1 CH'D DIM WAS Ø2.285 IS Ø1.95. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	10/23/2014	DPD	JAG
3	15-0243	UPDATED TO NEW DRAFTING STANDARDS. C3-8-3-2 DELETED; REPLACED WITH 32446 .	8/25/2015	DPD	JAG



NOTE:

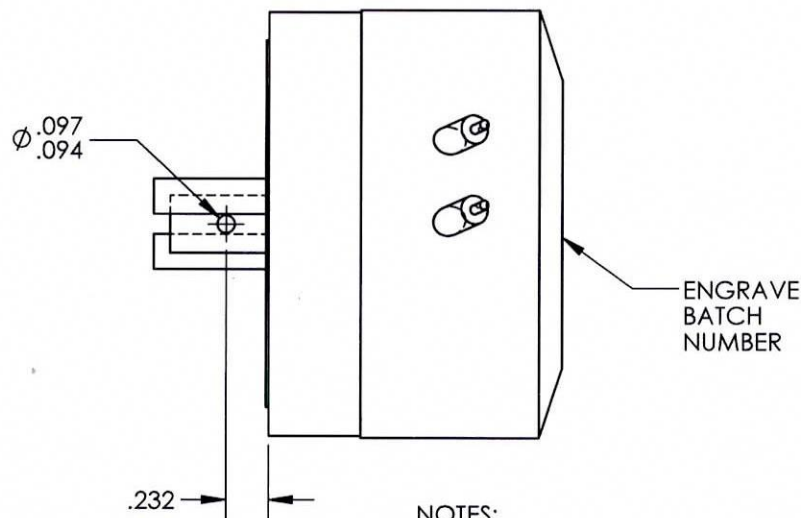
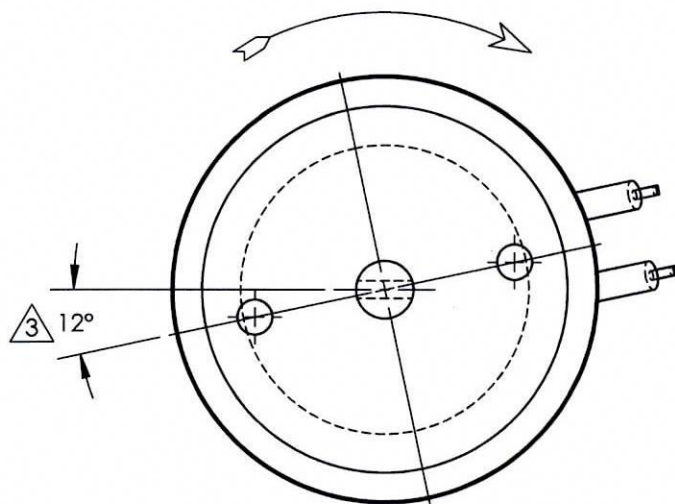
¹ CONNECTIONS SUPPLIED LOOSE.

DART AEROSPACE	
TITLE SOLENOID ASSEMBLY	
DWG NO. C3-8-2	REV 3
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: CANAM APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 12/19/2001 SHEET 1 OF 4

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		B/O	C3-8-2-1	1	SOLENOID		TESTCO #152951-001	1,2
			C3-8-2-2	1	SOLENOID PIN SPACER	303 S.S.		3
		B/O	C3-8-3	1	SPRING PIN	18-8 S.S.	Ø3/32 X 1/2 (MCMaster-CARR #92373A143)	1
		B/O	C3-8-3-1	1	SPACER	PETG		4
		B/O	32446	2	22-16 AWG KNIFE CONNECTOR		(ALLIED ELECTRONICS 32446)	1

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REVISIONS						
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2	14-0195	C3-8-2-1 CH'D DIM WAS LIMITS Ø.0933-.0937 IS LIMITS Ø.094-.097. ADDED "(CLOCKWISE)" TO NOTE 3. CH'D NOTE 4 WAS PLACE BUSHING AND PIN IN PLACE AS SHOWN AFTER DRILLING IS INSTALL SPACER AND PIN IN PLACE AS SHOWN ON SHEET 1 AFTER DRILLING. ADDED ENGRAVE BATCH NUMBER NOTE.	10/23/2014	DPD	JAG	



NOTES:

1. USE C3-8-2-F1 FIXTURE FOR DRILLING THE PIN HOLE.
2. REMOVE COIL SPRING BEFORE DRILLING HOLE.
3. TURN SHAFT AS SHOWN IN FIXTURE BEFORE DRILLING (CLOCKWISE).
4. INSTALL SPACER AND PIN IN PLACE AS SHOWN ON SHEET 1 AFTER DRILLING.

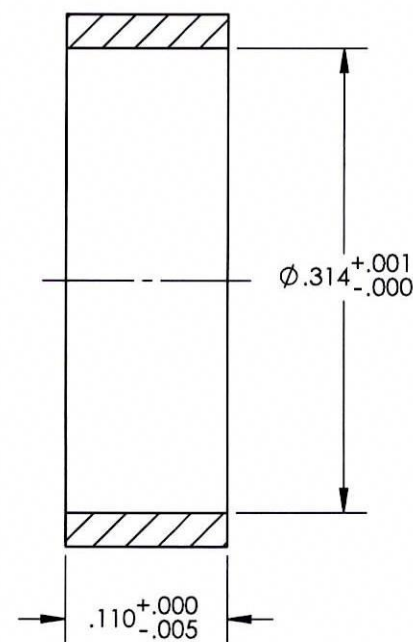
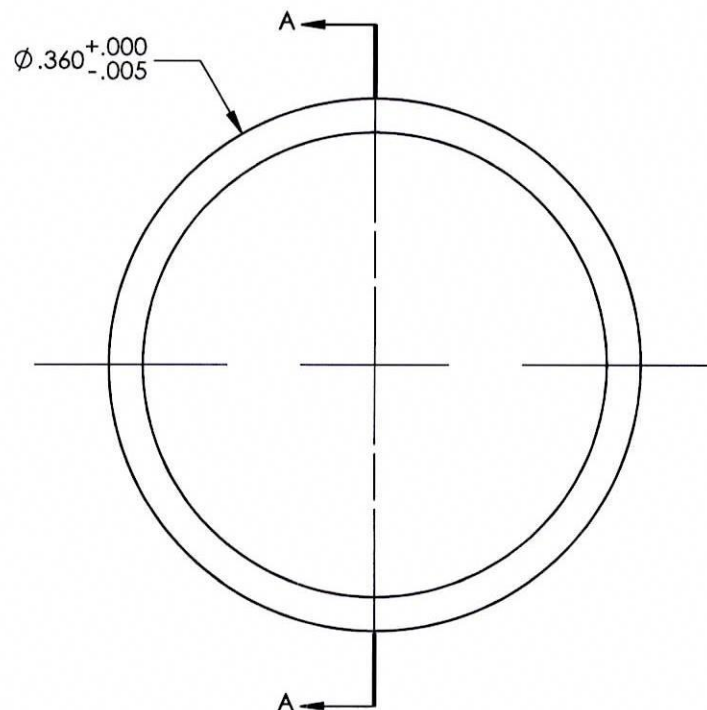
(C3-8-2-1)

SOLENOID WITH PINNED HOLE

DART AEROSPACE	
TITLE SOLENOID ASSEMBLY	
DWG NO. C3-8-2	REV 3
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	DRAWN BY: CANAM APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL
SCALE 1:1	DATE 12/19/2001 SHEET 2 OF 4

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



SECTION A-A

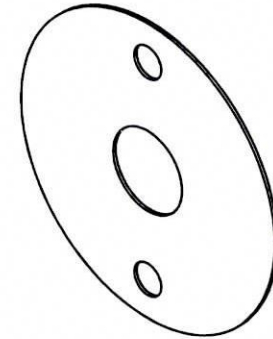
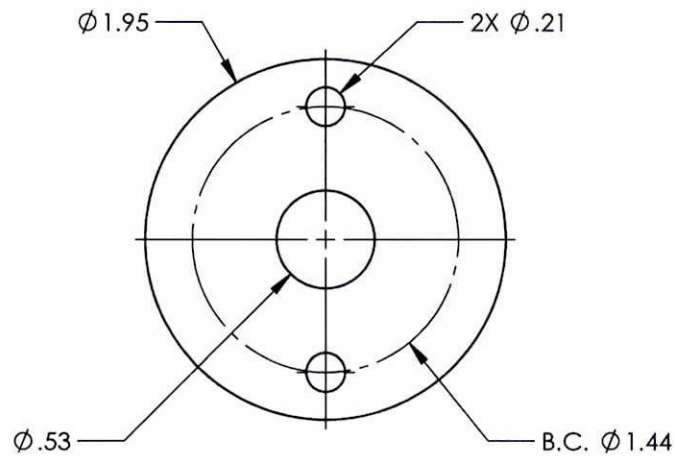
C3-8-2-2

SPACER

DART AEROSPACE	
TITLE SOLENOID ASSEMBLY	
DWG NO. C3-8-2	REV 3
MAT'L 303 S.S.	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT
.XX ± .01 ANGLES ± .5°	TREAT
.X ± .1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 8:1	DATE 10/31/2001 SHEET 3 OF 4

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		ADDED SPACER C-3-8-3-1	10/10/2012	RJC	DW
2	14-0195	C3-8-3-1 CH'D DIM WAS Ø2.285 IS Ø1.95.	10/23/2014	DPD	JAG



C3-8-3-1

SPACER

DART AEROSPACE	
TITLE SOLENOID ASSEMBLY	
DWG NO. C3-8-2	REV 3
MAT'L PETG UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± .5° .X ± .1	DRAWN BY: APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE SHEET 4 OF 4